Work Order ID 98609

Friday, March 15, 2013 8:52:25 AM

98609

Page 1

Item ID:

D4003-13

Accept

N900040100

Setup Start

Revision ID: Item Name:

Fwd Fuel Gutter Line

Start Date:

3/15/2013

Start Qty: 5.00 **Req'd Qty:** 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 3/22/2013

Process Plan: W

Date: 13-3-15

Tooling:

Date:

Run

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ **Work Center ID** Operation Description

Revision Nbr

Set Up/ **Run Hours**

Tool ID

Tool # Plan Accept Code **Qty**

Reject Qty

Stop

Reject Insp. Number

Stamp

D4003

Draw Nbr

Α

100

100 Small Fab

Memo

0.00

0.00

Small Fab

1- Cut tube as per dwg

110

110

OC. Quality Control QC5- Inspect part completeness to step on W/O

170

Identify as per dwg & Stock Location 57

170

Packaging

Memo

Memo

0.00

5x

Packaging

NCR: Y	es /	No				WORK ORDER NON-C	CON	FOR	MANCE / UP	DATE				
											QA Closed:	Date	•	
Work Order:						DISPOSITION	,	AGAINST DEPARTMENT/PROCESS						
Part No.						Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			-	Water Jet d. Eng. Coor.	Engineering Quality Other	
NCR N	No					Work Order Update		mem	Large Fab	Finishing Composite				
Root					Descri	ption of work order update	lr	nitial	· Ac	ction	Sign &			
Cause	D	ate St	ер	Qty	(or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling			l											
Operator			1											
Material														
Setup			1											
Other			ł						į					
Process				-										
Supplier			Ì											
Training														
Unapproved											<u> </u>			
							AUL	CATE	GORY					
Landi	ng Gear				_	General	_			 -	٦	-	-	
	-	ding			<u> </u>	Bend	$\boldsymbol{\vdash}$	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced	
	Cen	tre Not Co	ncen	tric to (o/s _	BOM/Route	$\boldsymbol{\vdash}$	Hardwa		<u> </u>	Over/Under	 	Temperature/Cure	
	Crac				<u> </u>	Broken/Damaged	-	-	ion Incomplete	<u> </u>	Part Incorred	<u> </u>	Weld	
	$oldsymbol{oldsymbol{ o}}$	shed/Crim	ped		<u> </u>	Burrs	-		ions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuff				_	Contamination	\vdash	Mainte			Part Moved			
	_	t Treat			L	Countersink	\mathbf{H}	Mislabe		<u></u>	Positioned V	_	- 1	
		ection Str		Tube		Cut Too Short	\vdash	Misread	i		Power Loss/	Surge	Other	
	— ∵	oles in Ben				Drill Holes	\sqcup	Offset				. 4	, ,	
	—	que Wave:		xtrusio	\	Drawing	-		Calibration					
	∐ Turi	ning Seque	ence			Finish	Ш	Out of 9	Sequence					
	Wave/Twist in Tube				Folio		Outside	Dimensions						

DQA:

Date:

Friday, March 15, 2013 8:52:25 AM

Page 2

Item ID:

D4003-13

3/15/2013

Accept

N900040100

Setup Start

Revision ID:

Item Name:

Required Date: 3/22/2013

Fwd Fuel Gutter Line

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

Start Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description

Start Qty: 5.00

Req'd Qty: 5.00

Set Up/ **Run Hours** Tool ID

Tool # Plan Accept Qty Code

Reject Reject Qty

Insp. Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180 QC

Memo

0.00

Quality Control

pl 13-03-19

											DQA:	Date:	•
NCR:	/es	/ No				WORK ORDER NON-O	COf	NFOR	MANCE / UP	DATE			
									•		QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
, , , , , , , , , , , , , , , , , , ,	•		"-			Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	۱o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	<u></u>	Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	۷o.			<u>-</u>		Work Order Update	<u>.</u>	Į.	Large Fab	Composite]	Supplier	
Root	1			I	Descri	tion of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance		nief Eng	l	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							1						
Operator												ļ	
Material													
Setup													
Other													
Process	Ш						1						
Supplier	Ш]								
Training			1		İ								
Unapproved													
						F	AUI	LT CATE	GORY				
Landi	ng (Sear				General		_			_		,
		Bending				Bend	L	Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Г	Cracks				Broken/Damaged	Г	Inspect	ion Incomplete	Γ	Part Incorre	ct	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes Drawing

Finish Folio

Picklist Print

Friday, March 15, 2013 8:52:25 AM

Work Order ID:

98609

Parent Item:

D4003-13

Parent Item Name:

Fwd Fuel Gutter Line

Start Date: 3/15/2013

Required Date: 3/22/2013

Page 1

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP rev A 10.01.12 new issue prelim EC verified by:DD

DD verf:EC

IPP Rev:B 10.06.22 per dwg rev:A

	00												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.035 6061-T6 RD Tube .375 x.	035W	Purchased	No			100	f	234.0722	0.125	0.625	- 1		17 m7 15
				Location		Loc Oty	Lo	oc Code	•		đ		13-03-15

											DQA:	Date	e:
NCR: Y	'es	/ No				WORK ORDER NON-	COI	VFORM	MANCE / UP	DATE	QA Closed:	Date	2:
Mork Orde	· .					DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Nork Orde Part N NCR N	lo					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
WCK 1	•0.					Work Order opdate	_		Large rab	composite		Jappher	
Root Cause		Date	Step	Qty		ription of work order update or Non-conformance		Initial nief Eng		tion ription	Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup other rocess upplier raining napproved													
			<u> </u>	•			FAUL	T CATE	GORY				
Landi		1				General	FAUL	·	JORT				_
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete cions Incomplete/l enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
						Finish	-	Out of S					

Outside Dimensions

Wave/Twist in Tube

Folio

3 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4003-13 REF JCA-M47-2-22 С Ø0.375 NOM 0.035 REF **D4003-13 FORWARD FUEL GUTTER LINE** NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.375 X 0.035 WALL THICKNESS PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF DART SPEC M6061T6T0.375W.035 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED 2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs REV. A D4003 MFG. APPR SHEET 9 OF 9 APPROVED TITLE SCALE LINE DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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		DQA:	Date:	• . \
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

										<u></u>	QA Closed:	Date	2:		
Work Orde	or.					DISPOSITION AGAIN					NST DEPARTMENT/PROCESS				
Part No						Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineer Qual Oth	lity	
Root					Descri	ption of work order update	Ī	nitial	Ac	tion	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inst	ector	
Doc/Data															
Equip/Tooling															
Operator						•									
Material			ļ												
Setup			į												
Other															
Process													,		
Supplier													1		
Training												1			
Unapproved			<u> </u>								<u> </u>	<u> </u>			
							AUL	T CATE	GORY						
Landi	ng (1			_	General	_	7			7	_	_		
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	<u> </u>	Cracks			L	Broken/Damaged		1	ion Incomplete		Part Incorre	⊢	Weld		
	L	Crushed/	'Crimped		<u> </u>	Burrs	_	4	ions Incomplete/	Unclear	Part Lost/M	· ·	Wrong Stoc	k Pulled	
	Cuffs					Contamination	<u></u>	Mainte			Part Moved				
	Heat Treat					Countersink		Mislabe	eled		Positioned \		_		
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		Ripples in	n Bend			Drill Holes		Offset						,	
		Torque V	Vaves in (Extrusion	ր _	Drawing	L	4	Calibration						
		Turning S	Sequence	!		Finish	L	Out of	Sequence						
1	1	Wave/Tw	vist in Tul	be	l	Folio	Outside Dimensions								